

06611624

MODEL 766™ M24

Model S&S™

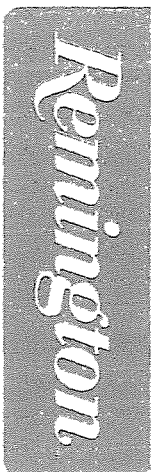
Action

Barrel Length

Capacity

Order No. 5716

*Includes 1 in chamber.



M2400079806

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Smith

Remington[®]

VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

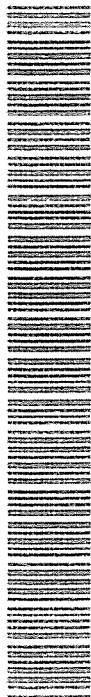
REG. U.S. PAT. & TM. OFF.

DUPONT

MODEL 700TM M24

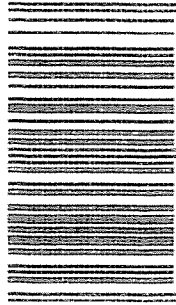
SERIAL NO. C6611624	
ORDER NO. 5716	30

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat. & Tm. Off. Marca Registrada Marque Deposee.



5716 C6611624

LPC



0 47700 25716 7

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6611624

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1 16 91		RW
600	Proof	1 18 91		RW
607	Check Headspace	1 18 91		RW
610	Dis-assemble Gun	1 18 91		RW
612	Magnaflux Barrel Action	1 18 91		KR
	Magnaflux Bolt	1 18 91		KR
615	Rollmark Caliber	1 18 91		LG
617	Drill and Tap Sight Holes	1 24 91		FB
618	Polish Barrel	1 18 91		W/B
620	Apply Coatings (Barrel Action)		2/15/91	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		2/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		2/19/91	RW
	C) Inspect Ejector Hole for Chamfer		2/19/91	RW
	D) Oil Firing Pin Ass'y		2/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		3/4/91	TH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			3/4/91	JH
	G) Safety Off Force	3	3	3			3/4/91	JH
	H) Trigger Pull Test & Retainability						3/4/91	JH
	I) Firing Pin Indent	.0215	.0215	.022			3/4/91	JH
	J) Assemble Stock						3/5/91	RW
	K) Assemble Swivel Studs						3-8-91	DH
	L) Attach Front and Rear Sight Assemblies						3/5/91	RW
	M) Iron Sight Alignment						3/5/91	RW
	N) Detach Front & Rear Sights & place in numbered container						3/5/91	RW
	O) Attach Scope to Rifle						3/5/91	RW
	P) Detach & Attach Scope 20 Times						3/5/91	RW
640	Gallery Target & Test						3-5-91	N
	A) Time							N
	B) Malfunctions							N
	C) Pierced Primers							N
	D) Optical Clarity of Scope							N
645	Inspect for Live Ammo						3-5-91	N
655	Final Inspection							
	A) Headspace						3-8-91	DH
	B) Trigger Pull	2.13	2.19	2.18	2.24	2.19	3-8-91	JH
	C) Function						3-8-91	DH
660	Pack						3-14-91	N

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. 6611624

DATE 3/4/91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.39	2.40	2.13	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.42	2.39	2.38	2.19	
PULL #3	2.35	2.35	2.26	2.18	
PULL #4	2.38	2.36	2.35	2.24	
PULL #5	2.17	2.36	2.38	2.19	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.28		
PULL #2	3.30	3.18		
PULL #3	3.30	3.26		
PULL #4	3.32	3.16		
PULL #5	3.32	3.25		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.35	4.14		4.21
PULL #2	4.26	4.21		4.24
PULL #3	4.23	4.24		4.29
PULL #4	4.25	4.21		4.29
PULL #5	4.26	4.23		4.29
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611624
6 Mar 1991

CENTROIDAL DISTANCES

0 TO 1	.243977
1 TO 2	.29908
1 TO 3	.153473
1 TO 4	.235187
1 TO 5	.306687

✱ <----POA

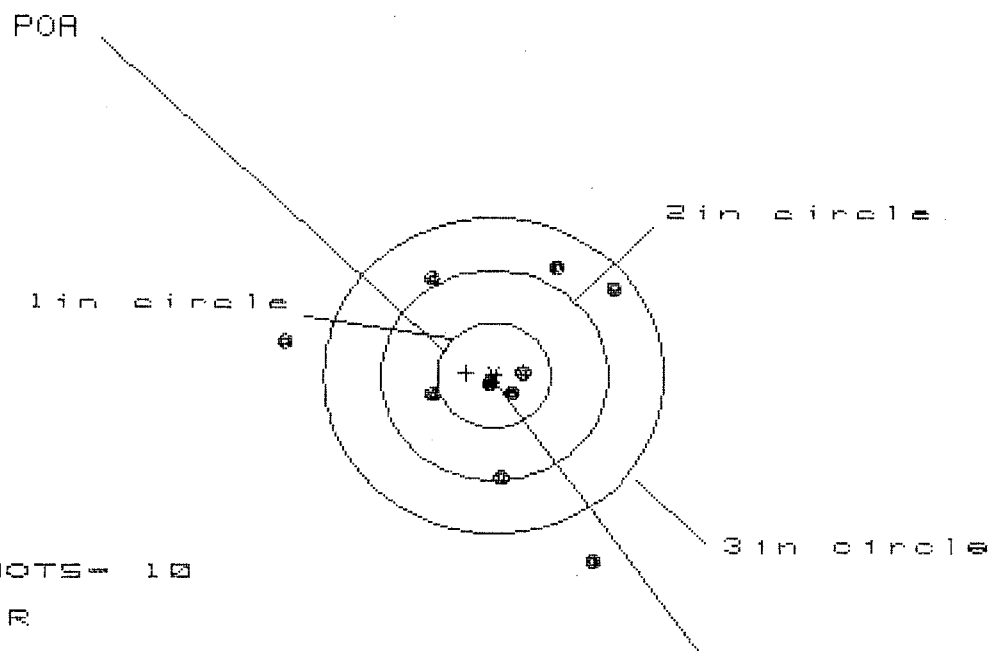
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0764
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1172
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .139903
THE AMR FOR THIS RIFLE IS: 1.04

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11624

CENTERFIRE PATTERNS

1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 5

3 in = 8

HS= 2.914

VS= 2.794

GS= 3.461

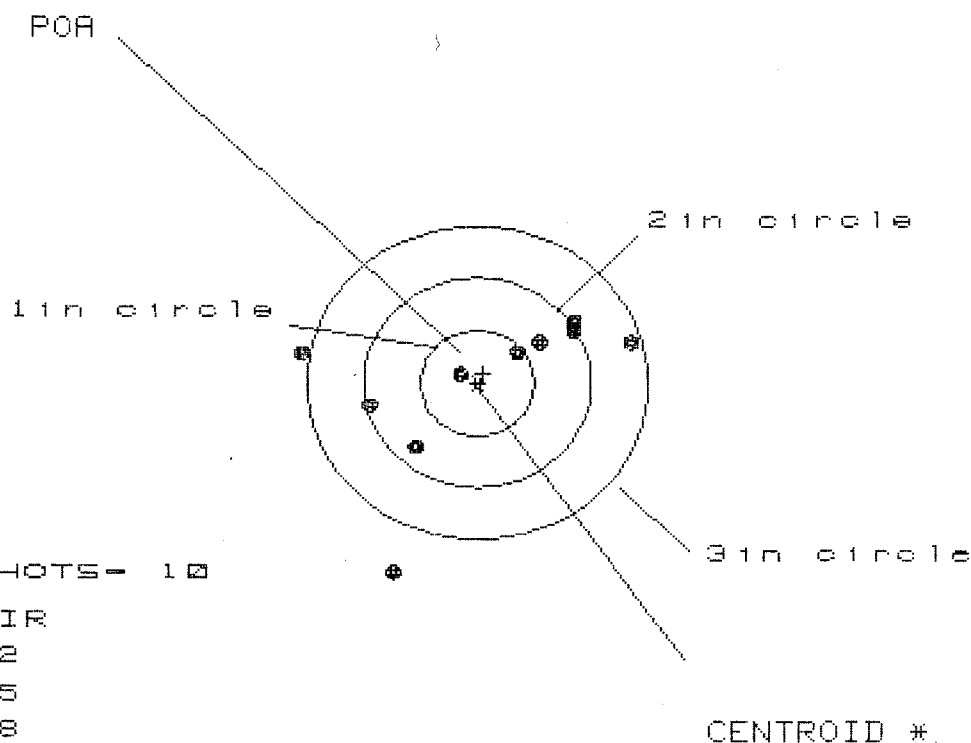
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.068	1.169	.951
MINIMUM X	-1.846	-1.745	-.689
MAXIMUM Y	.987	.786	.798
MINIMUM Y	-1.807	-1.142	-1.130
CENTROID X	.242	.141	.359
CENTROID Y	-.031	.170	.158
POR TO CENTROID in.	.244	.221	.392
MIN RADIUS	.070	.259	.173
MEAN RADIUS	.958	.870	.730
MAX RADIUS	2.022	1.747	1.172
HORIZONTAL SPREAD	2.914	2.914	1.640
VERTICAL SPREAD	2.794	1.928	1.928
EXTREME SPREAD	3.461	2.972	2.081
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	8		

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611624

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.849

VS= 2.394

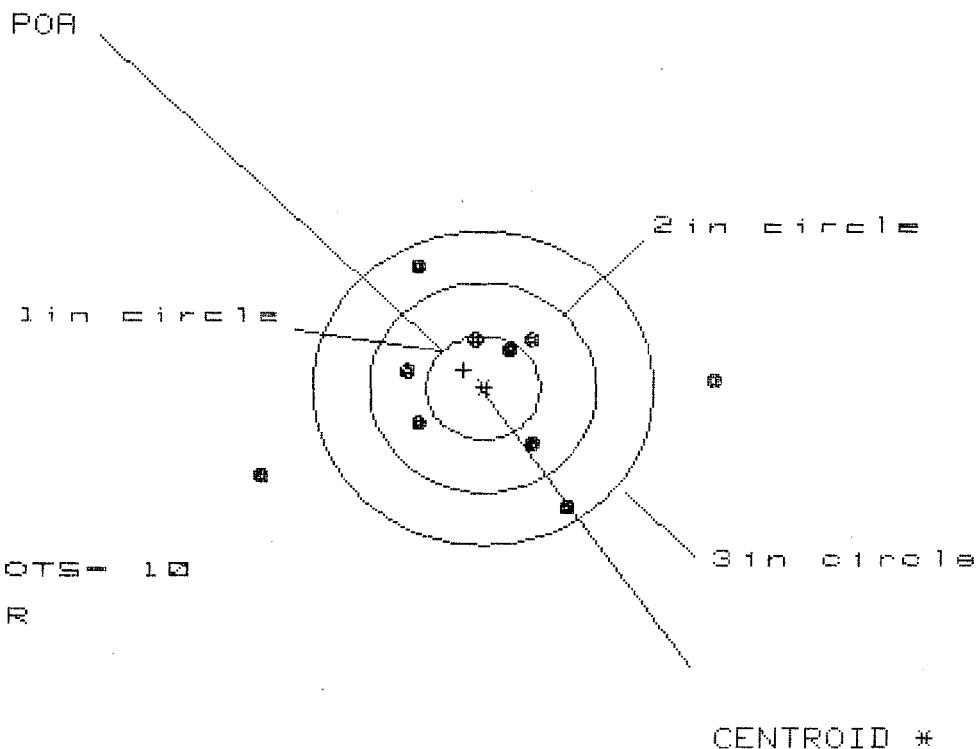
GS= 3.071

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.245	1.045
MINIMUM X	:	-1.516	-1.604	-1.266
MAXIMUM Y	:	.600	.401	.411
MINIMUM Y	:	-1.794	-.805	-.795
CENTROID X	:	-.051	.037	.237
CENTROID Y	:	-.091	.108	.098
POA TO CENTROID in.	:	.104	.114	.257
MIN RADIUS	:	.180	.230	.097
MEAN RADIUS	:	1.006	.860	.719
MAX RADIUS	:	1.962	1.606	1.314
HORIZONTAL SPREAD	:	2.849	2.849	2.311
VERTICAL SPREAD	:	2.394	1.206	1.206
EXTREME SPREAD	:	3.071	2.852	2.384
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611624

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS= 3.975

VS= 2.357

GS= 4.075

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.025	1.808	.706
MINIMUM X	:	-1.950	-.874	-.648
MAXIMUM Y	:	1.215	1.126	1.128
MINIMUM Y	:	-1.142	-1.231	-1.229
CENTROID X	:	.169	.386	.160
CENTROID Y	:	-.166	-.077	-.079
POA TO CENTROID in.	:	.237	.394	.178
MIN RADIUS	:	.435	.306	.351
MEAN RADIUS	:	1.039	.902	.766
MAX RADIUS	:	2.106	1.808	1.417
HORIZONTAL SPREAD	:	3.975	2.682	1.354
VERTICAL SPREAD	:	2.357	2.357	2.357
EXTREME SPREAD	:	4.075	2.831	2.680
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611624

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 9

HS= 1.615

VS= 3.128

GS= 3.367

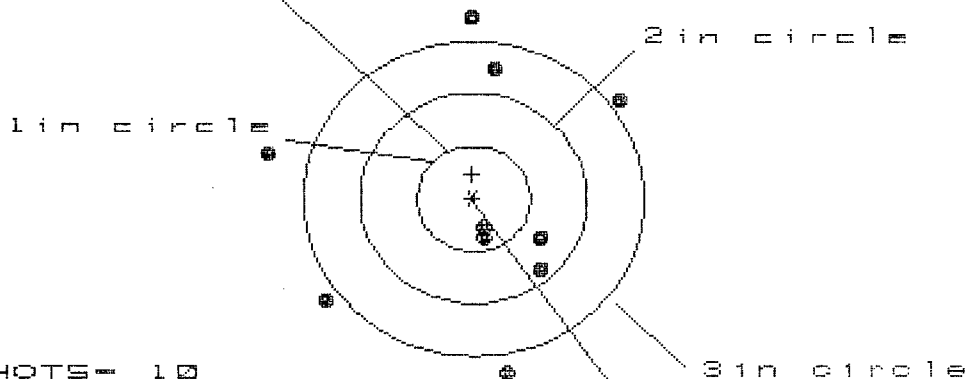
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.983	.714	.723
MINIMUM X	:	-.712	-.612	-.683
MAXIMUM Y	:	1.961	1.566	1.027
MINIMUM Y	:	-1.167	-.950	-.754
CENTROID X	:	.009	-.091	-.100
CENTROID Y	:	-.063	-.280	-.476
POA TO CENTROID in.	:	.063	.295	.487
MIN RADIUS	:	.487	.448	.325
MEAN RADIUS	:	.989	.796	.651
MAX RADIUS	:	2.158	1.568	1.256
HORIZONTAL SPREAD	:	1.615	1.326	1.326
VERTICAL SPREAD	:	3.128	2.516	1.781
EXTREME SPREAD	:	3.367	2.536	2.022
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611624

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 4

3 in = 5

HS= 3.150

VS= 3.378

GS= 3.391

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.324	1.121	1.089
MINIMUM X	:	-1.826	-1.557	-1.589
MAXIMUM Y	:	1.703	1.750	1.514
MINIMUM Y	:	-1.675	-1.628	-1.409
CENTROID X	:	.013	.216	.248
CENTROID Y	:	-.235	-.282	-.501
POA TO CENTROID in.	:	.235	.355	.559
MIN RADIUS	:	.295	.273	.136
MEAN RADIUS	:	1.209	1.092	.942
MAX RADIUS	:	1.875	1.791	1.723
HORIZONTAL SPREAD	:	3.150	2.678	2.678
VERTICAL SPREAD	:	3.378	3.378	2.923
EXTREME SPREAD	:	3.391	3.391	3.245
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		5	